

Work Order ID **55961**



Page 1

February 8, 2010 11:41:13 AM

Item ID: D4055-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Back

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4055

*PAT PAS*

*Q Rev A*

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: *11330*  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note required

*Pat 10-2-08*  
*(3)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

*Pat 10/3/08*  
*(3)*

120

QC6- Inspect dimensions to drawing

0.00



QC

*Stops to premen Day only*

Memo

0.00

Quality Control

**QC APPROVAL**

**PRELIMINARY ISSUE**

*changes on Dwg parts no longer match*  
*no inspected to A release Day.*

*8/10/04/22*

*Pat*  
*KLASH*  
*Pat*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Changes - from 33.13 in now 33.28" 5.35 to 5.06"					

Part No: D4055-9 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: / Date: 10/09/01  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>55961</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/22	120	Changes from PA1 to PA2 Dwg. parts no longer conform	N/A	Red tag all parts in stock.	Yes parts are good for weldment. Very minor changes	N/A	10/09/01	8 10/04/22

NOTE: Date & initial all entries

# Work Order ID 55961

February 8, 2010 11:41:14 AM



Page 2

Item ID: D4055-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Back

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

N/A

E  
10.04.19

150

Identify as per dwg & Stock Location: prelim

0.00



Packaging

Memo

0.00

Packaging

E 10.04.19

(3) - 1 on w/o 56762

# Work Order ID 55961

February 8, 2010 11:41:14 AM



Page 3

Item ID: D4055-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Back

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*to test*

POSITIVE RECALL

EFFECTIVE 10-22-08 AUTH h

RELEASED J DATE 10-25-01

Qty 1

## Picklist Print

February 8, 2010 11:41:09 AM

Page 1

**Work Order ID:** 55961



**Parent Item:** D4055-9





**Parent Item Name:** Tank Back

**Start Date:** 2/08/10**Required Date:** 2/22/10

**Comments:** IPP RevA: new issue DD 10.01.08 verified by:JLM

**Start Qty: 3.00**

**Required Qty: 3.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-9P  Tank Back		Purchased	No			110	Each	0.0000	3.0000 		<i>ME</i> 10-4-19	



180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
04	03	10	0433668	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	0210447	PO11330
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION	
3	D4055-9P	TANK BACK CERTIFICATE OF CONFORMANCE REQ	
MFG. JOB# <u>JO210447-001</u> QTY <u>3</u>			
(1) Box			

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

10/06/08

CERTIFICATE NO. 1 OUR JOB NO J0210447 SHIPPING MEMO 0433668

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>3 PCS</u>	<u>PO11330</u>	<u>D4055-9P</u>		<u>TANK FWD END</u>	<u>PA1</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T6</u>		<u>SAMUEL / ALCOA INC</u>		<u>608951</u>		

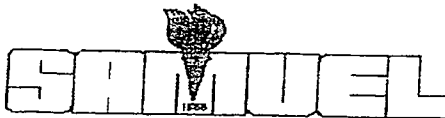
	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0210447-001 (3 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 04 MARCH 2010

G.F.I. Q.C. REP. Cartier-Haché





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'URFE, QUEBEC, CANADA  
H9X 3T5  
(514) 457-3399 FAX (514) 457-9393

No 001591859



PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME  
ASTERO TRANSPORT

CAMION/TRUCK 099  
NOM DE LA BRANCHE/SALES BRANCH NAME  
SAMUEL & FILS & CIE (QUEBEC) L

DATED'EXP/DATE OF SHIPMENT  
2/16/10

**VENDU À/SOLD TO:**

GFI, DIVISION DE THOMAS & BETTS LTEE  
180 LABROSSE

POINTE-CLAIRE  
QC

H9R1A1

(514) 630-4877

**EXPÉDIÉ À/SHIP TO: TÀB: PPD**

GFI INC.  
180 LABROSSE

POINTE-CLAIRE  
QC

H9R1A1

CA

(201009-00001)

N° COMMANDE  
N° ITEM  
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423  
4 PCS AL. SH. 6061 T6  
.0630"x48"x144"  
QQA 250/11

Cert/Test: FAX  
174 LVR

#Pièce AS06348144QM

Description	Art	Pd ca	Qté	#Étiq	Vendeur Org
#Étiq mln	#À soul			Étq princ	#Coul
764479	4	192.000	174	4947487	ALR US
Total:	4	192.000	174	D654824	608951

Poids total:

174 LVR

#Total paquets: 1

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ  
LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ  
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX  
SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS  
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

*Mélissa Diamond*  
MÉLISSA DIAMOND  
ADMINISTRATION  
DATE 16/02/10



NIR: R-539477-1

PAR	PORTAIRE/READ	PORTAIRE/READ	POST VOITUR ER/PAVER/INSTRUCTORS	REÇU PAR/RECEIVED BY
CHARGES				
EXPÉDITEUR/DISPATCHER			VOITUR ER/DRIVER	



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

1058276 0  
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 1  
2009-10-15 4303234 00000 1000143904-6 DCE-43904-6  
P.O. No./Govt Contract No. Customer Alcoa Item  
N22238 Ln#: 6 SAMUEL SON & CO LT G041110647R02

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3T5 QC

Item Description  
0-063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -  
.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-  
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EXC\_MRK ASME-SB-  
209 REV 07 EXC\_MRK ASTM209 REV 07  
CMMPO25 REV S CMMPO19 REV D ((MARKED))  
KRAFT PAPER INTERLEAVED MAX GROSS  
SKID WGT: 4500 LB QUAN TOL +/-30 %  
CQR 0222751 REV 02 CUST REQ 09-10-  
01 \*\*\* W/E 09-10-24 \*\*\*

8/10/08

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	764477	608951	4119	100	PC	:	27299 47004
2	764478	608951	3408	83	PC	:	27299 47004
3	764479	608951	4149	100	PC	:	27299 47004
			11676	283			

Notes for CQR: 0222751.2

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISION DATED 1997-08-01.

CQR: 0222751.2 -Specification Limits

Temp Dir	UTS	TYS	ELAD							Other	Other
T6 Long Transv.	KSI	KSI	PCT							Each	Total
Max	42.0	35.0	10	SI	FE	CU	MN	MG	CR	ZN	TI
Min				0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15
				0.40		0.15		0.8	0.04		

Chemical Composition  
Alloy 6061  
REMAIN

# CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

1058276

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2009-10-15

4303234

00000

1000143904-6

DCE-43904--

P.O. No./Govt Contract No.

Customer

Alcoa Item

N22238 Ln#: 6

SAMUEL SON & CO LT 0041110647R02

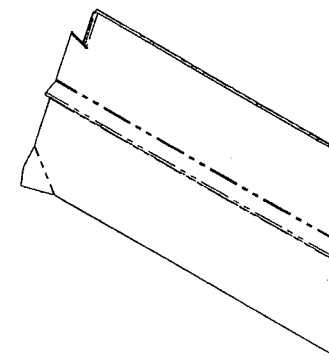
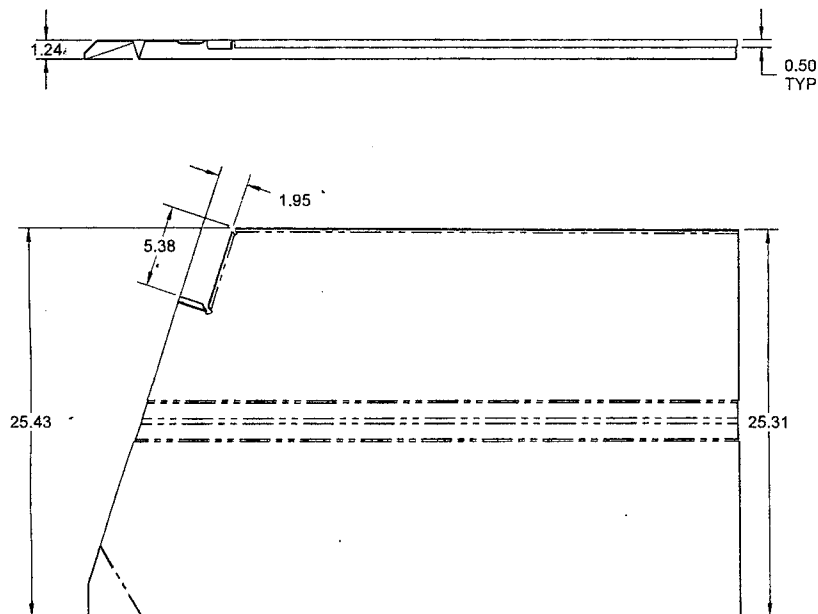
CQR: 0222751.2 -Specification Limits (cont.)

Lot: 608951 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



# **D4055-9 TANK BACK**

**PRELIMINARY ISSUE**

10.01.11

## **NOTES:**

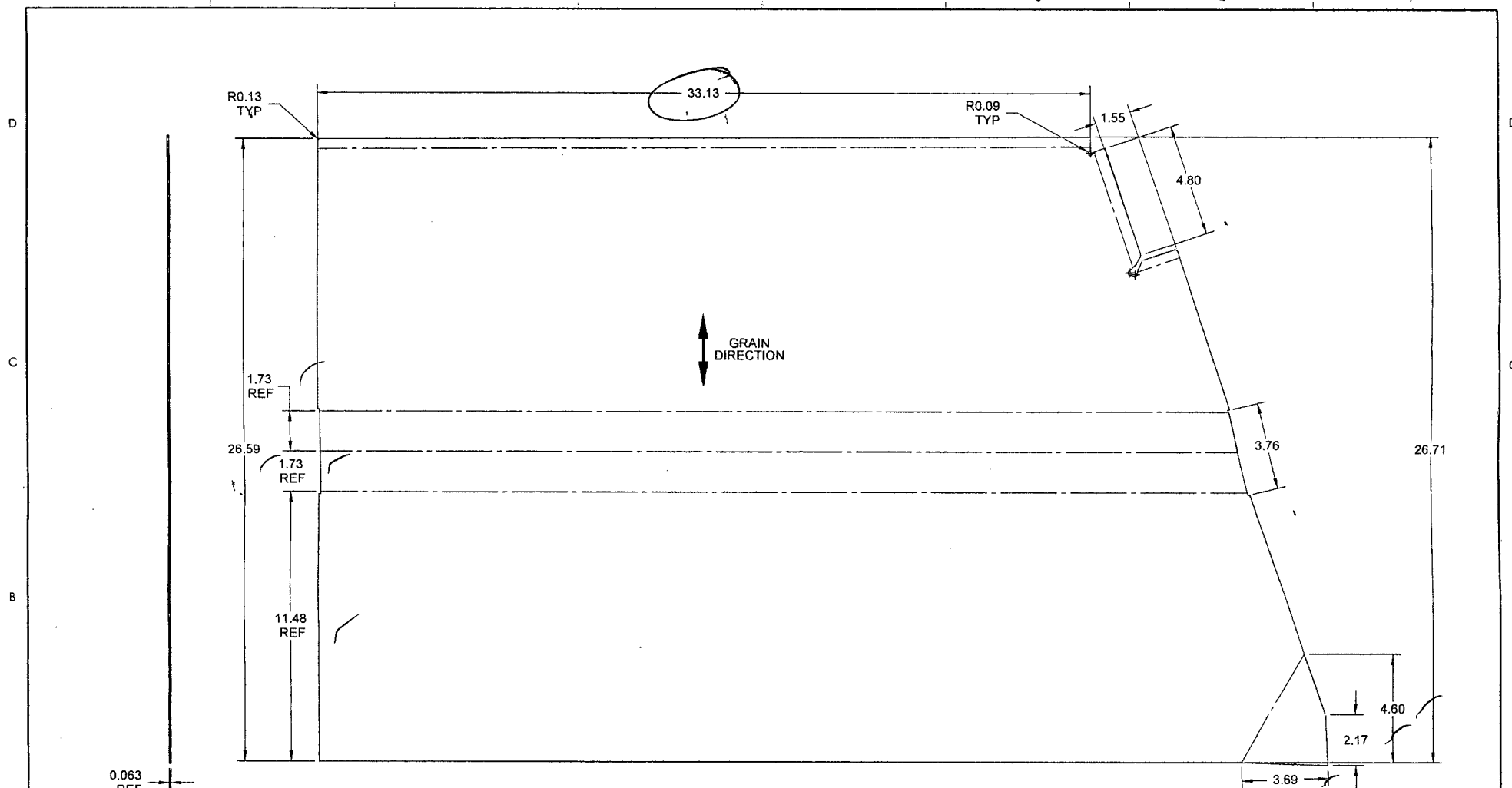
- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 10.01.11

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4055** REV. PA1  
TITLE **TANK** SCALE NTS  
SHEET 12 OF 15

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# **D4055-9F FLAT PATTERN**

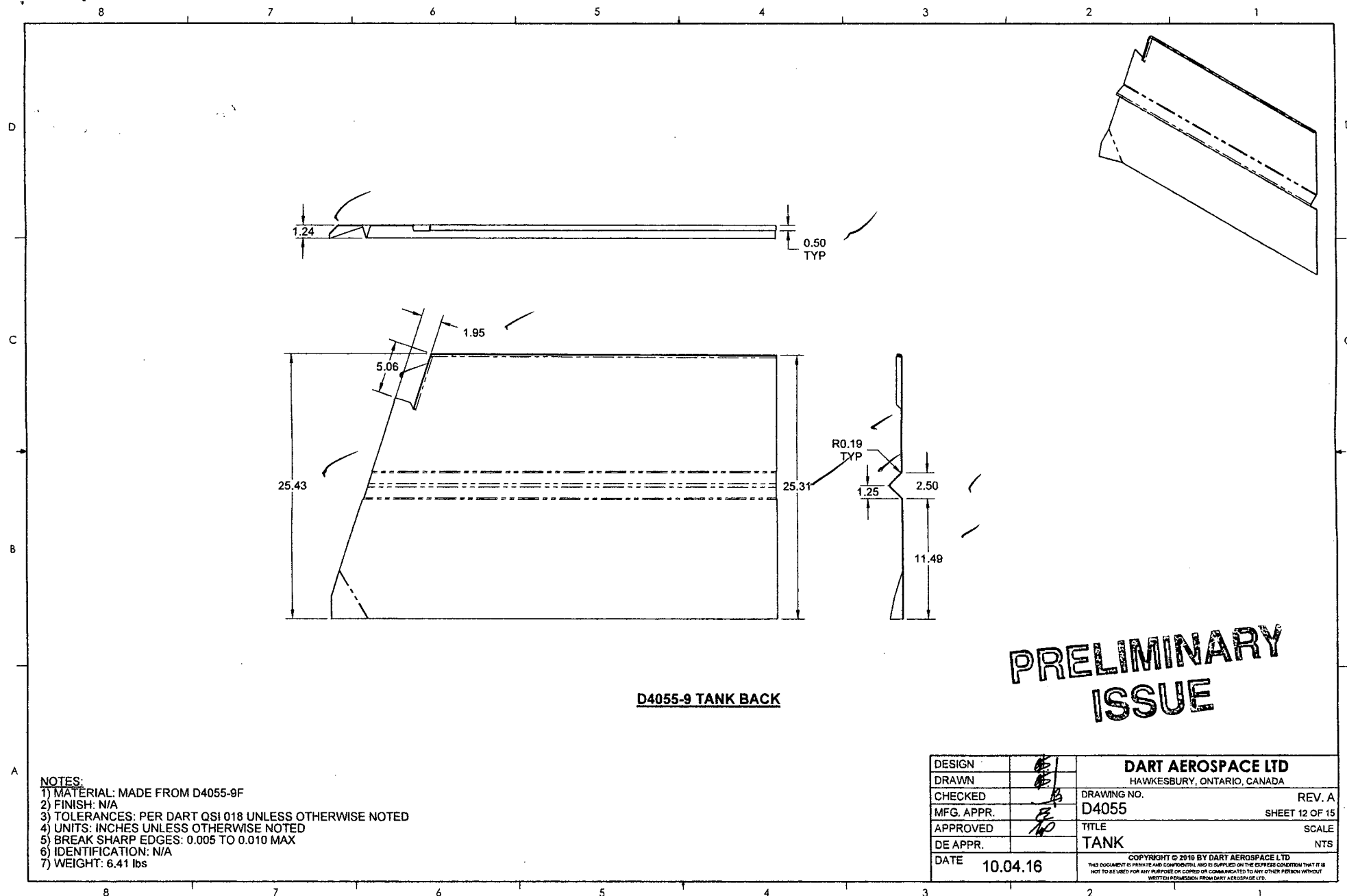
**PRELIMINARY ISSUE**

10.01.11

## **NOTES:**

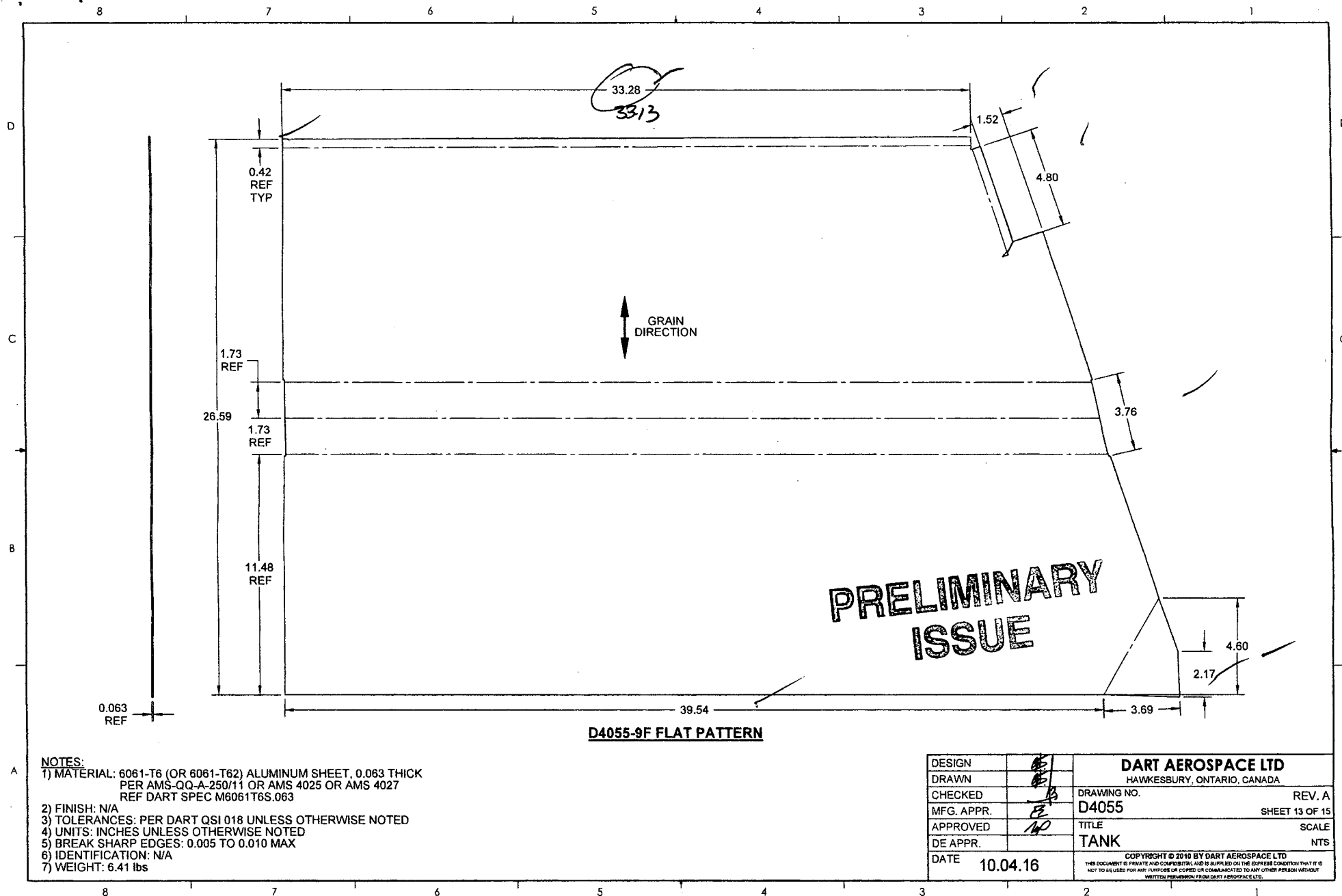
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4055</b>	SHEET 13 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	10.01.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 6.41 lbs

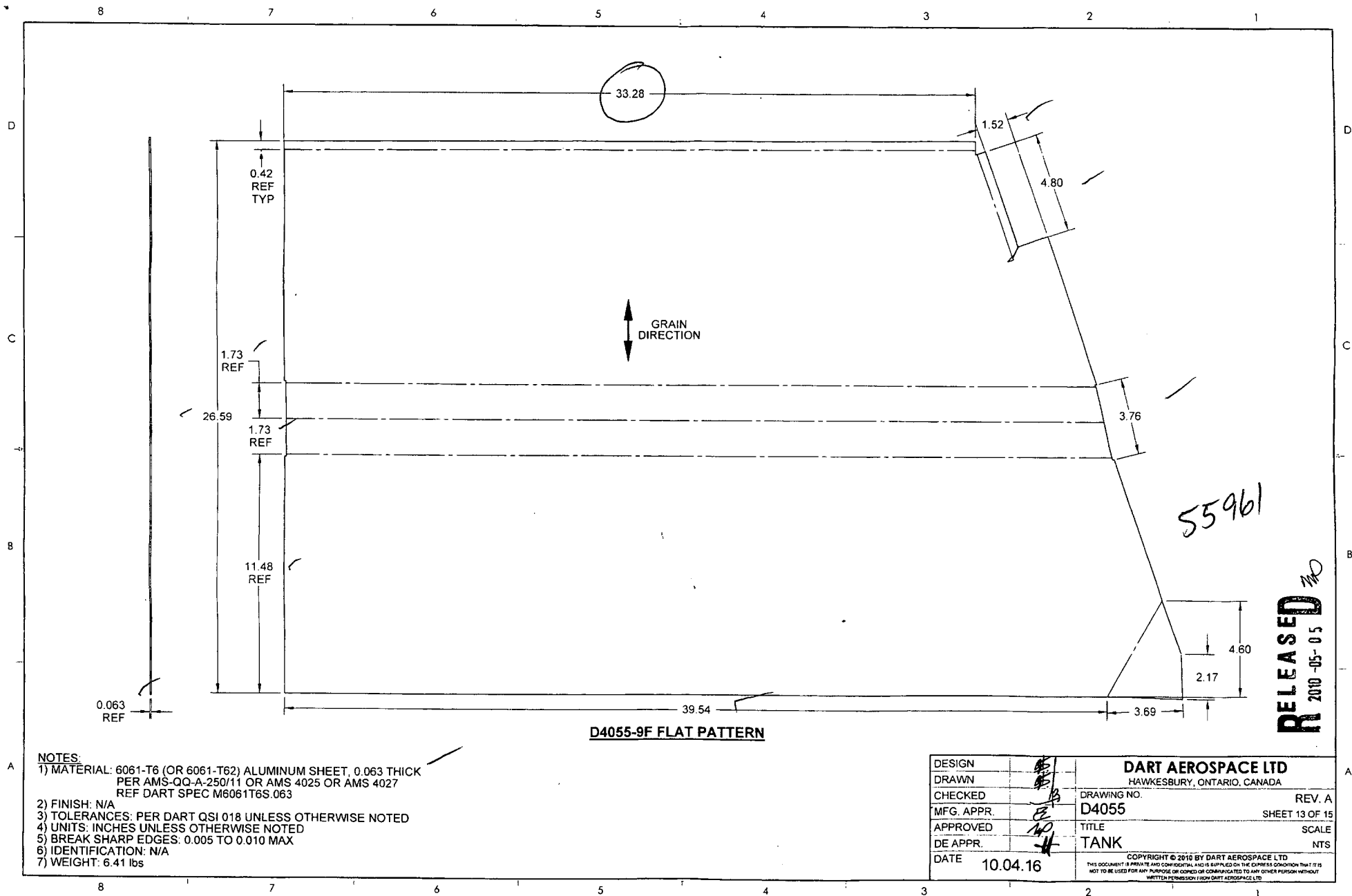
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	<b>D4055</b>	SHEET 13 OF 15
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	<b>10.04.16</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**RELEASED**  
R 2010-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

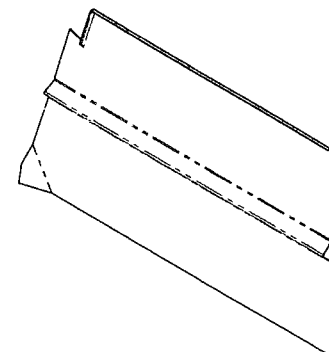
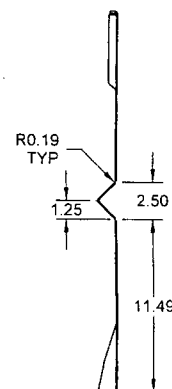
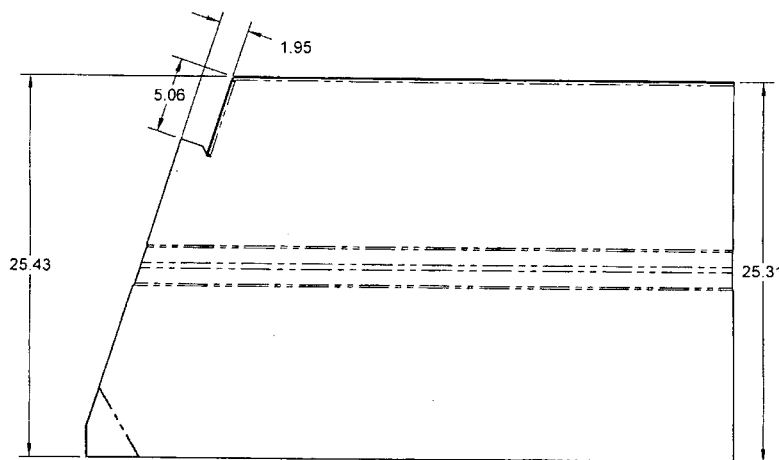
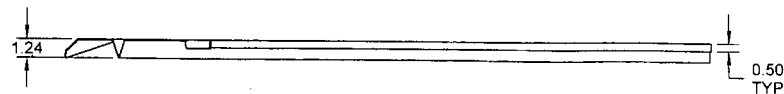
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			







**NOTE:** Date & initial all entries





**D4055-9 TANK BACK**

- NOTES:
- 1) MATERIAL: MADE FROM D4055-9F
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 6.41 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4055</b>	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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55961  
**RELEASED**  
2010-05-05  
JMD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries